

NEW PARAGRAPHS TO BE INSERTED AFTER PARAGRAPH 0014

Fig. 2 shows simultaneous machining of a single workpiece by two spindle heads:

Fig. 3 shows stocking of a second magazine by a second operator.

REPLACEMENT PARAGRAPH 0018

[0018] The tool changers 6, 7 enable very short ~~clamping-to-clamping~~ chip-to-chip times because the time for exchanging the tools falls within the main machining time of the machine tool as a result of moving the tool magazines 2, 3. Advantageously, the double gripping device 24, 25 of the tool changer 6, 7 does not pick up the tool 8, 9 directly from the tool magazines 2, 3 but from a ready position 4, 5.

REPLACEMENT PARAGRAPH 0020

[0020] The machine operator can now easily and comfortably stock the tool magazine 2 in the stocking position 14 with the required tools. During the stocking process, the tool 9 of the ~~spindle 12~~ of the spindle head 13 machines the workpiece 11. In this stocking phase, the machining center 1 operates with half its production capacity.

- 4 -

12/14/04: Amd for Ser. No. 10/065,021 - Inventor(s): Kurz et al. - Filing Date: 9/11/2002